

Date: Thursday, 18/09/2008 11:14:05 AM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : AFT BASE
Job Number : 42116	
Estimate Number : 13036	
P.O. Number :	Part Number : D365111
This Issue : 18/09/2008 S.O. No. :	Drawing Number : D3651 REV.B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 39938	Material :
Written By :	Due Date : 25/09/2008 Qty: <u>4</u> Um: Each
Checked & Approved By : <u>JUL 08.9.18</u>	
Comment : Est Rev:A New Issue 07-09-27 DD verified by: EC	
Est Rev:B ECN 1113P 08-01-22 DD	
Est Rev:C ecn1162 08-04-02 DD verified by: ec	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	G89	coated cloth
-----	-----	--------------



Comment: Qty.: 0.7203 sf(s)/Unit Total: 3.6015 sf(s)

G-89 coated cloth

Batch: 105928 1B 8-9-23

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------

**Comment:** FLOW WATER JET

1-Cut as per Dwg D3651

Dwg Rev: B
 Prog Rev: B

1B 8-9-23

(4)

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

1B 8-9-23**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------

**Comment:** SECOND CHECKS 08/09/23 (x4)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------

**Comment:** PACKAGING RESOURCE #1

Identify and stock

Location: 57 17718 08/09/23 (x4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 18/09/2008 11:14:05 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BASE

Job Number: 42116

Part Number: D365111

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/09/24 JF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-09-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 42116
Description: Gasket		Part Number: D3651-11
Inspection Dwg: D3651	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	.131	X			
Ø0.250	+0.005/-0.001	.253	X			
8.74	+/-0.030	8.74	*			
11.62	+/-0.030	11.625	*			
1.62	+/-0.030	1.626	X			
1.41	+/-0.030	1.420	X			
0.500	+/-0.010	.499	X			
0.600	+/-0.010	.606	X			
0.634	+/-0.010	.640	X			
2.564	+/-0.010	2.559	X			
2.081	+/-0.010	2.083	X			
3.731	+/-0.010	3.731	X			
2.100	+/-0.010	2.100	X			
9.706	+/-0.010	9.706	X			
7.969	+/-0.010	7.977	X			
6.96	+/-0.030	6.966	X			
5.698	+/-0.010	5.699	X			
3.698	+/-0.010	3.698	X			
2.564	+/-0.010	2.566	X			
2.020	+/-0.010	2.020	X			
3.284	+/-0.010	3.284	X			
2.200	+/-0.010	2.205	X			
2.750	+/-0.010	2.753	X			
9.521	+/-0.010	9.521	X			
10.22	+/-0.030	10.22	X			
1.373	+/-0.010	1.371	X			
1.62	+/-0.030	1.626	X			
3.564	+/-0.010	3.564	X			
4.236	+/-0.010	4.236	X			
5.636	+/-0.010	5.636	X			
7.049	+/-0.010	7.049	X			

Measured by: IB	Audited by: S	Prototype Approval:	N/A
Date: 8-9-23	Date: 08/09/23	Date:	N/A
Rev	Date	Change	Revised by
A	08.04.17	New Issue	KJ/DD
			Approved
			DD

8 7 6 5 4 3 2 1

D

C

B

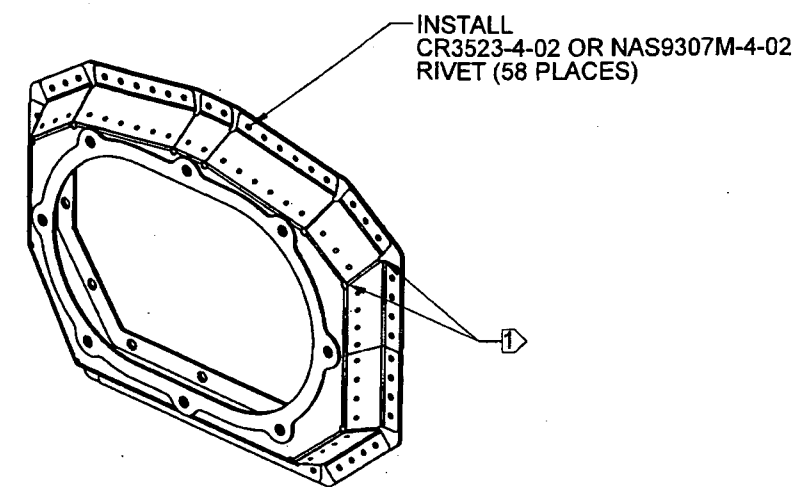
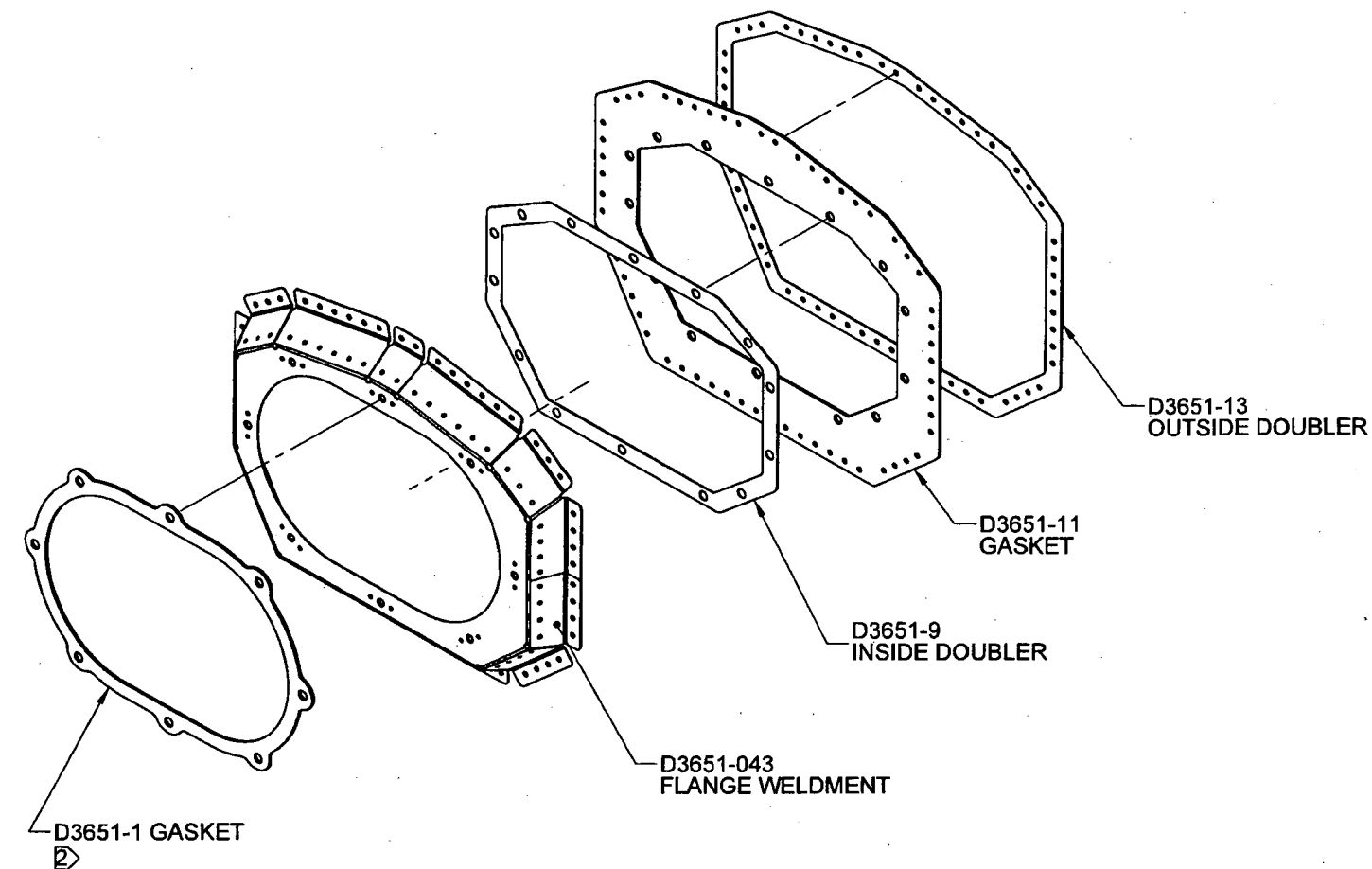
A

D

C

B

A



PART LIST

QTY	PART NUMBER	DESCRIPTION
-041		
X	D3651-041	AFT BASE ASSEMBLY
1	D3651-043	FLANGE WELDMENT
1	D3651-1	GASKET
1	D3651-9	INSIDE DOUBLER
1	D3651-11	GASKET
1	D3651-13	OUTSIDE DOUBLER
58	CR3523-4-02 or NAS9307M-4-02	RIVET

RELEASED
08.03.27

D3651-041 AFT BASE ASSEMBLY

D3651-041 NOTES:

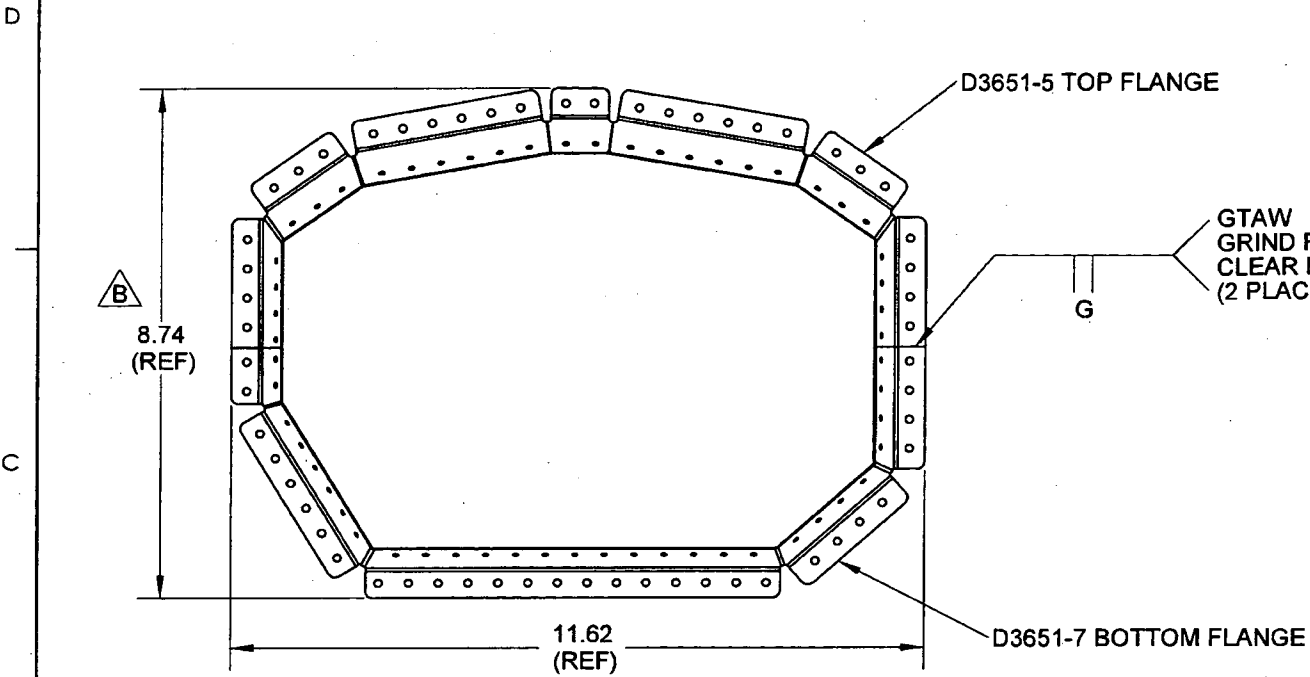
- 1) SEAL ALL MATING SURFACES AND GAPS USING PROSEAL 700 FIRE WALL SEALANT
- 2) INSTALL D3651-1 USING 3M HIGH PERFORMANCE CONTACT ADHESIVE 1357
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.6 lbs

B	SHEET 1: GENERAL UPDATE SHEET 2: 8.74 WAS 8.50; 0.88 WAS 0.98; REMOVED ANGLE SHEETS 4, 5, 6, 8 & 9: GENERAL DIMENSIONAL UPDATE SHEET 7: 5.514 WAS 5.504	RF	08.01.07
A	NEW ISSUE	RF	07.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	CE	DRAWING NO.	REV. B
MFG. APPR.	MA	D3651	SHEET 1 OF 5
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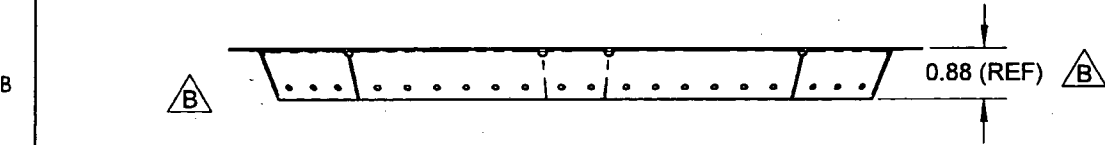
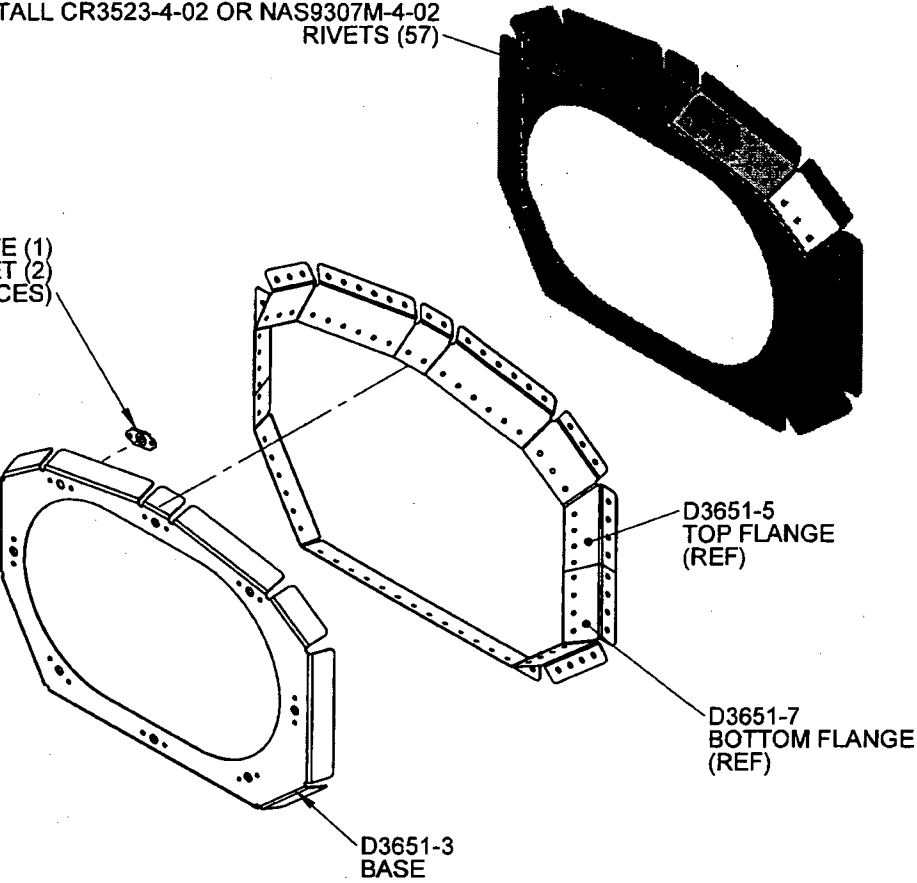
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8 7 6 5 4 3 2 1

TRANSFER DRILL Ø0.129 (#30 DRILL)
FROM D3651-5/-7 TO D3651-3
INSTALL CR3523-4-02 OR NAS9307M-4-02
RIVETS (57)



MS21060-3K NUTPLATE (1)
MS20427M3-3 RIVET (2)
(8 PLACES)



D3651-043 FLANGE WELDMENT

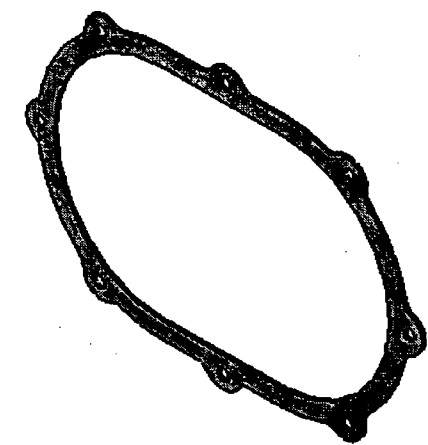
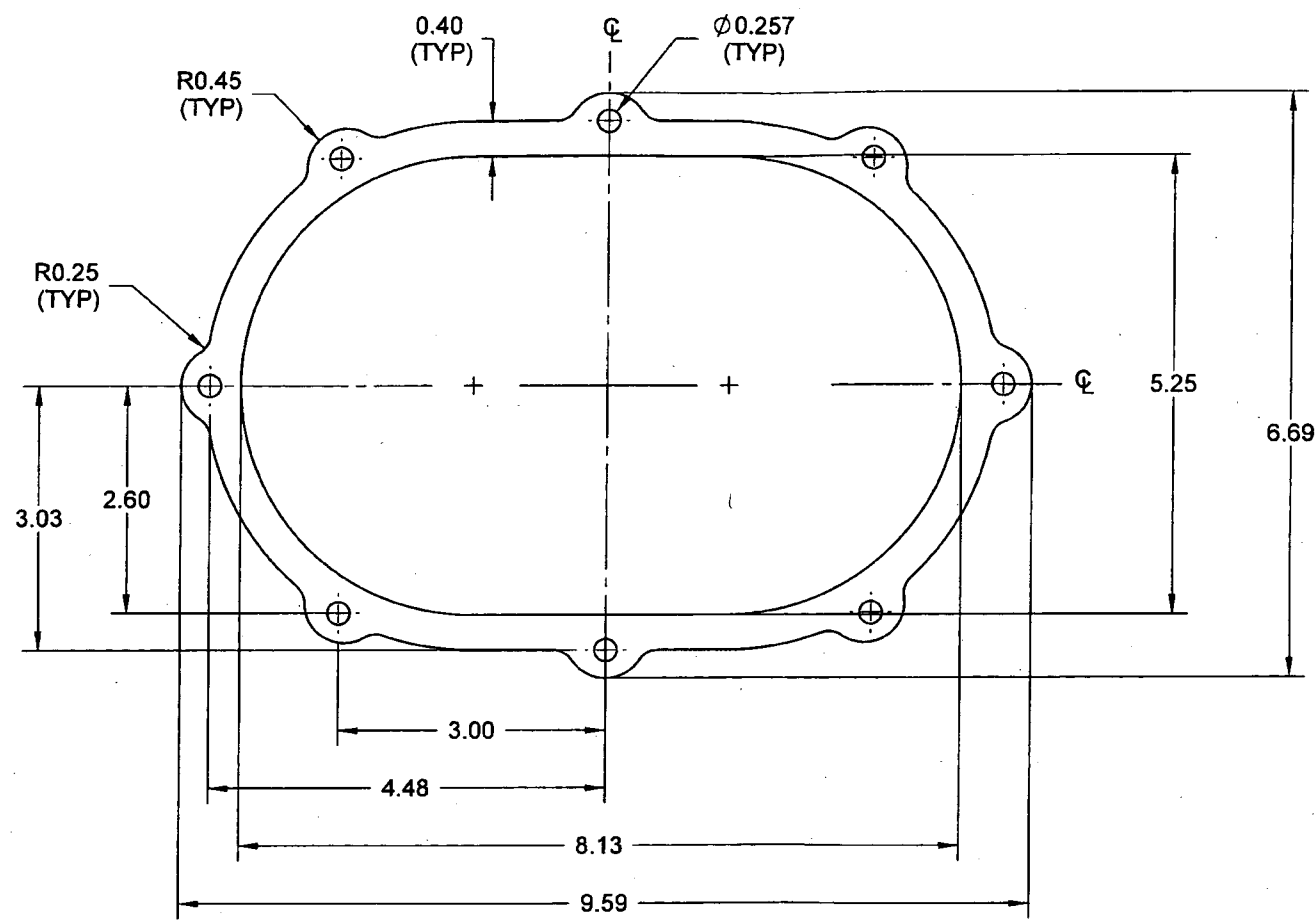
QTY -043	PART NUMBER	DESCRIPTION
X	D3651-043	FLANGE WELDMENT
1	D3651-3	BASE
1	D3651-5	TOP FLANGE
1	D3651-7	BOTTOM FLANGE
16	MS20427M3-3	RIVET
8	MS21060-3K	NUTPLATE
57	CR3523-4-02 or NA9307M-4-02	RIVET

RELEASED
08-03-27-14

- D3651-043 NOTES:
- 1) WELD PER QSI 004
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.76 lbs

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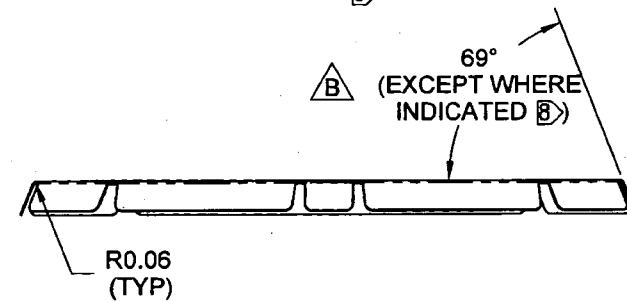
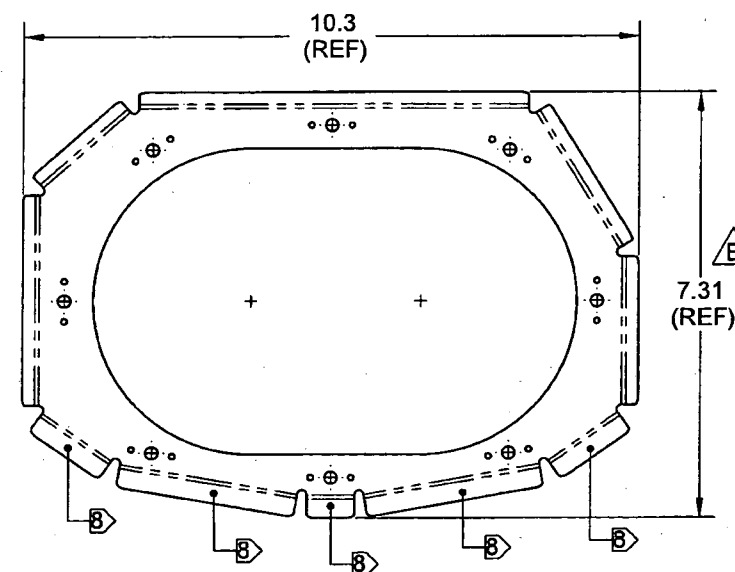


D3651-1 GASKET

- NOTES:**
- 1) MATERIAL: THERMO-CHEM P/N G-89, (REF. 0.060 THICK)
POSSIBLE SUPPLIER: A.R. THOMSON GROUP
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) PART IS SYMMETRIC ABOUT ϕ
 - 8) WEIGHT: 0.09 lbs

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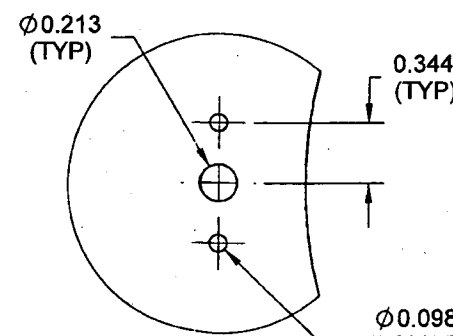
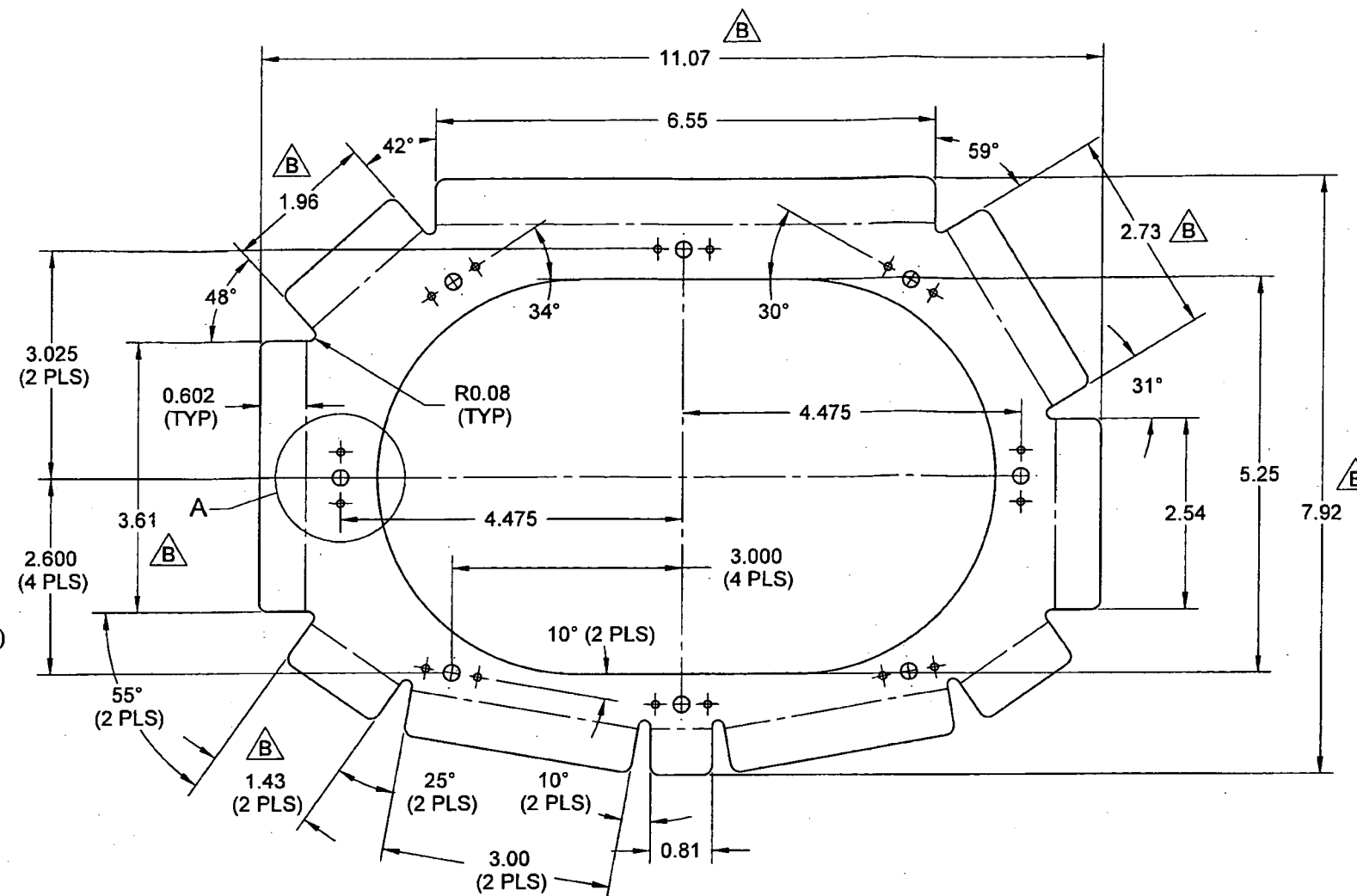
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D3651-3 BASE
(MAKE FROM D3651-3F FLAT PATTERN)

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.27 lbs
- 8) BEND TO 55° WHERE INDICATED

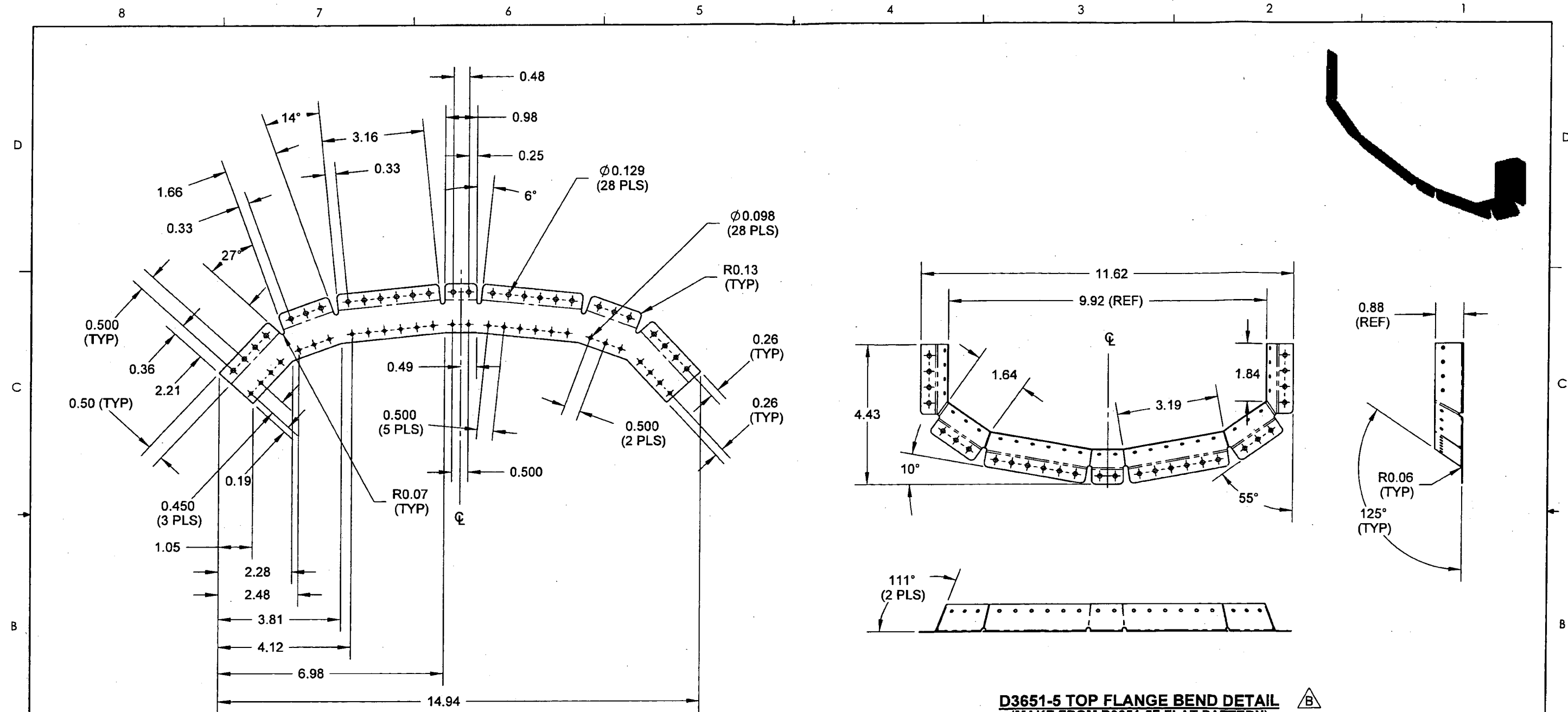


DETAIL A

D3651-3F FLAT PATTERN

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D3651-5 TOP FLANGE BEND DETAIL
(MAKE FROM D3651-5F FLAT PATTERN)

D3651-5F FLAT PATTERN 

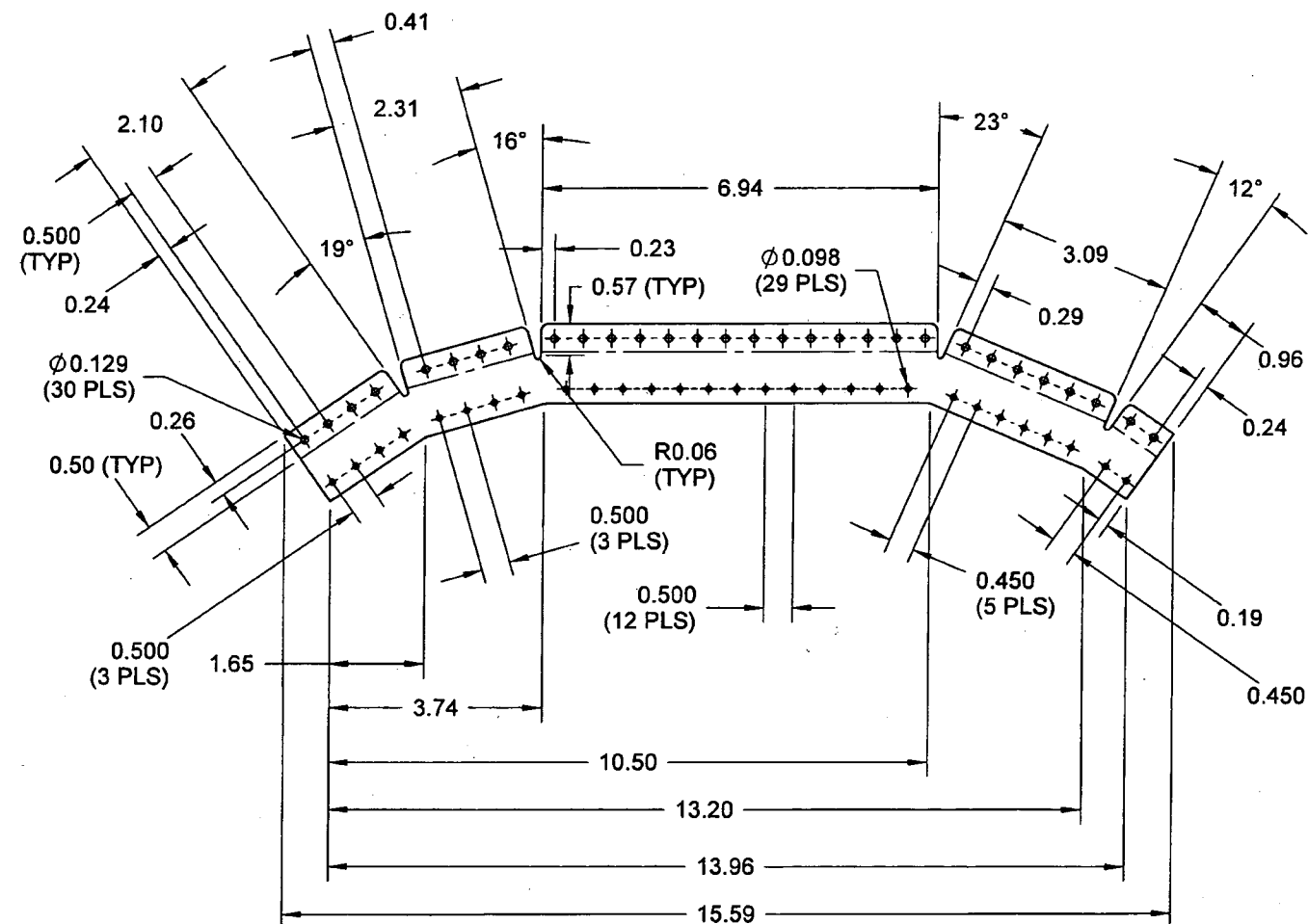
NOTES:

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.02 lbs

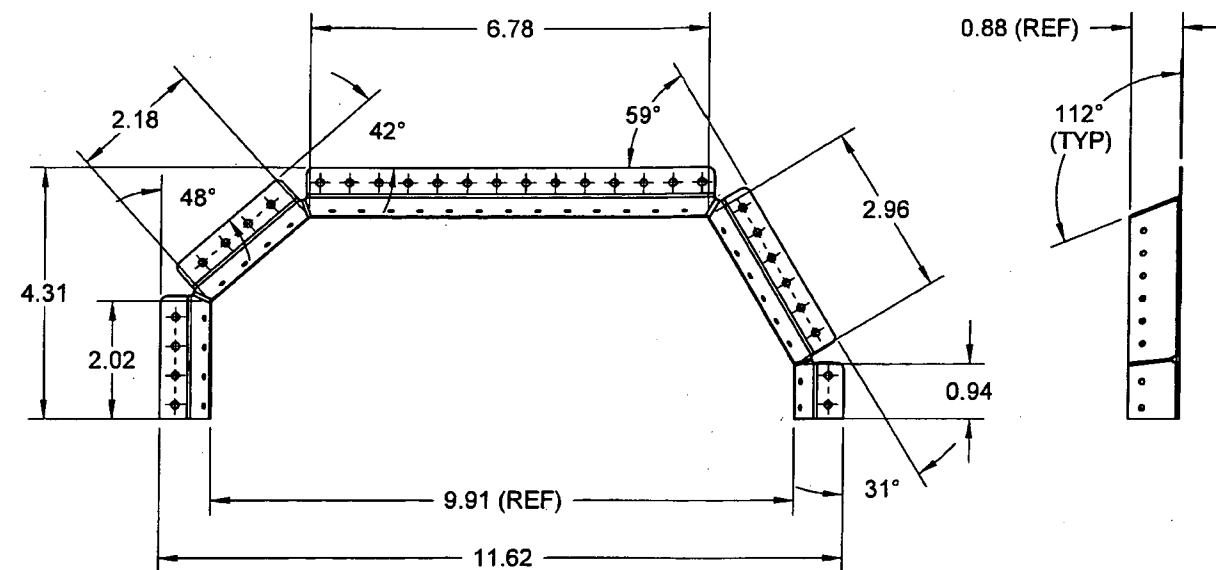
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DRAWN	RF		
CHECKED	LE	DRAWING NO. D3651	REV. B
MFG. APPR.	<i>[Signature]</i>		SHEET 5 OF 9
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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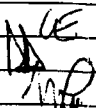
D3651-7F FLAT PATTERN B



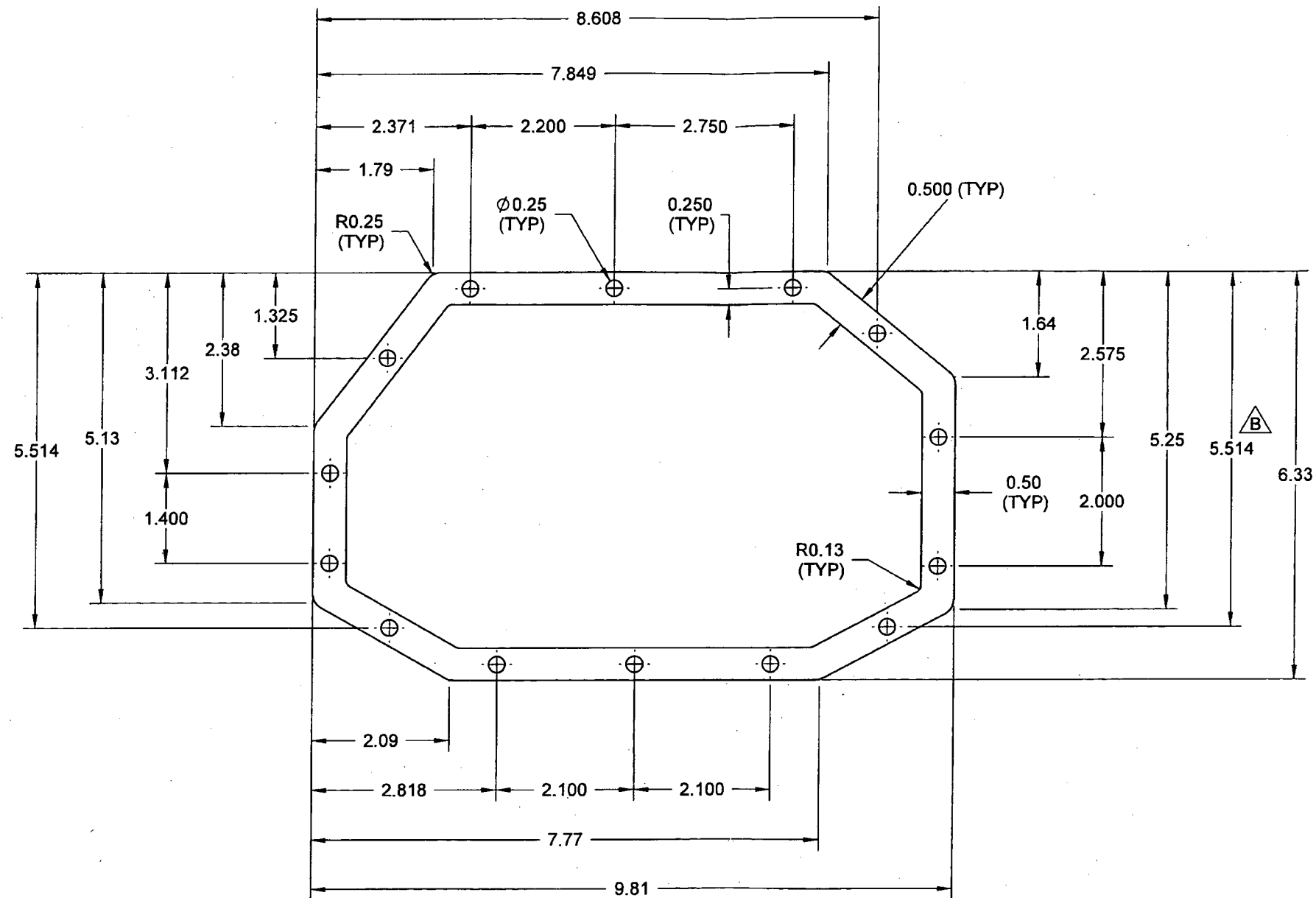
D3651-7 BOTTOM FLANGE BEND DETAIL B
(MAKE FROM D3651-7F FLAT PATTERN)

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

DESIGN	RF	DART AEROSPACE LTD	
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MFG. APPR.		D3651	SHEET 6 OF 9
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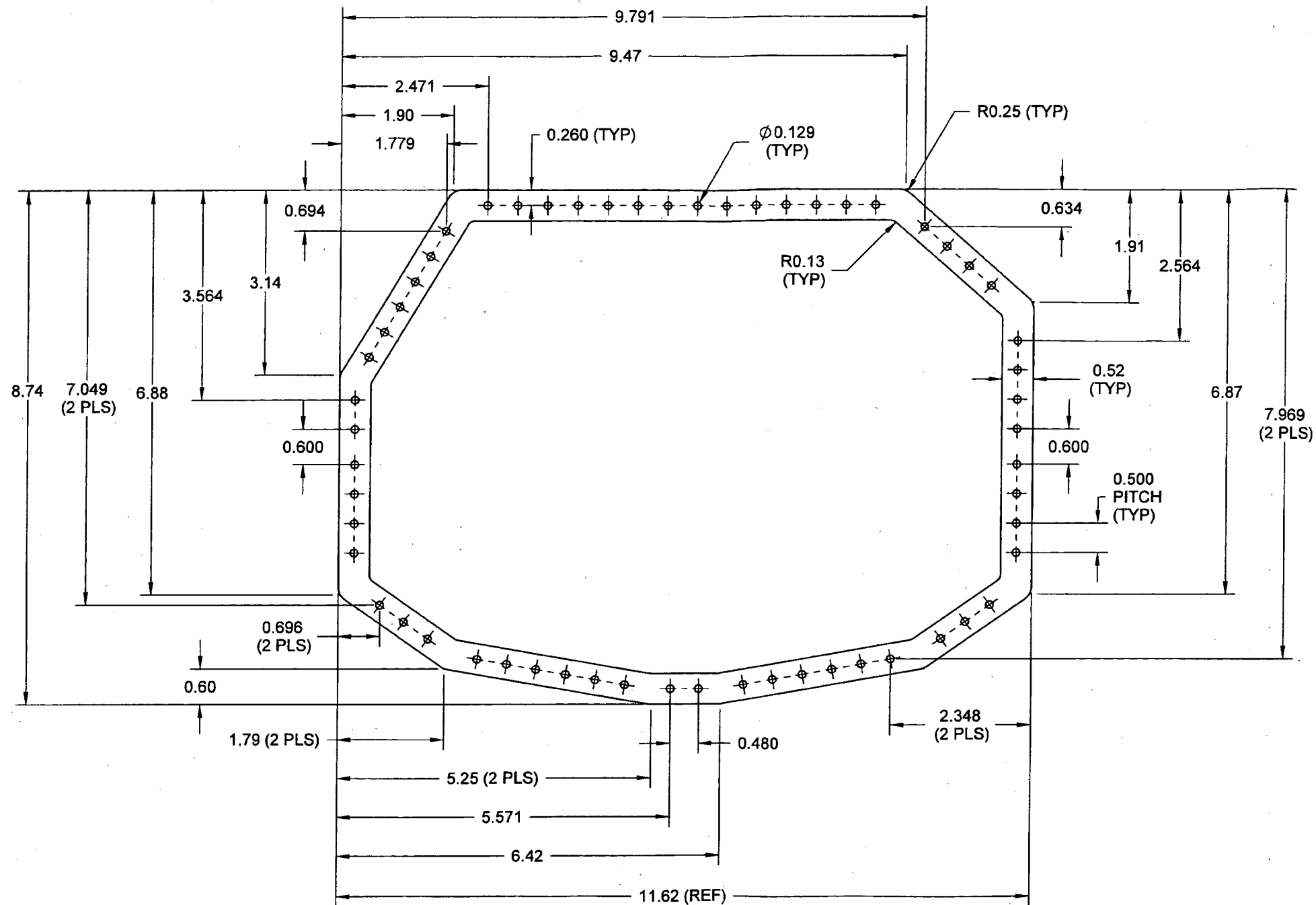
D3651-9 INSIDE DOUBLER

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.07 lbs

DESIGN	RF	DART AEROSPACE LTD	
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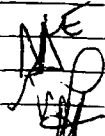
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D3651-13 OUTSIDE DOUBLER

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.10 lbs

DESIGN	RF	DART AEROSPACE LTD	
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CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3651	SHEET 9 OF 9
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